

Work Order ID 59024

Tuesday, May 25, 2010 8:20:53 AM



Page 1

Item ID: D3929-042

Accept



Setup Start



Revision ID:

Item Name: Gusset Assembly

Stop



Start Date: 5/25/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-5-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3929

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

304.125

1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B 10-5-26

6

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-5-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	11							

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	8 10/06/26			(6)			
140 Large Fab Large Fab	Memo Weld bushings D3907-1 as per dwg D3929 316L rod batch: <u>M113328</u>	0.00 0.00							10/06/03 (6)
150 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							(6) 10.06.04

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 25, 2010 8:20:57 AM

Page 1

Work Order ID: 59024



Parent Item: D3929-042



Parent Item Name: Gusset Assembly


Start Date: 5/25/2010

Required Date: 5/31/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	55.7800	0.45	2.842105	3.		

10-5-26

Location

Loc Qty

Loc Code

MAT

55.78

114488

55.78

114489

6

✓ D3907-1



Bushing

Manufactured

No

130

Each

48.0000

2

12

10/06/07

Location

Loc Qty

Loc Code

WA

48

57242

7

57937

41

7
5

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39024

BJ 10-5-28

D3929-041 GUSSET ASSEMBLY

D3929-042 GUSSET ASSEMBLY

RELEASED
8/6/12 MD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	DESCRIPTION	MB	09.04.03
REV.			BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.04.03			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3929** REV. A
SHEET 1 OF 3
TITLE **GUSSET ASSEMBLY** SCALE NTS

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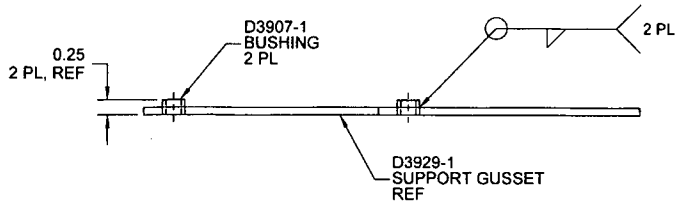
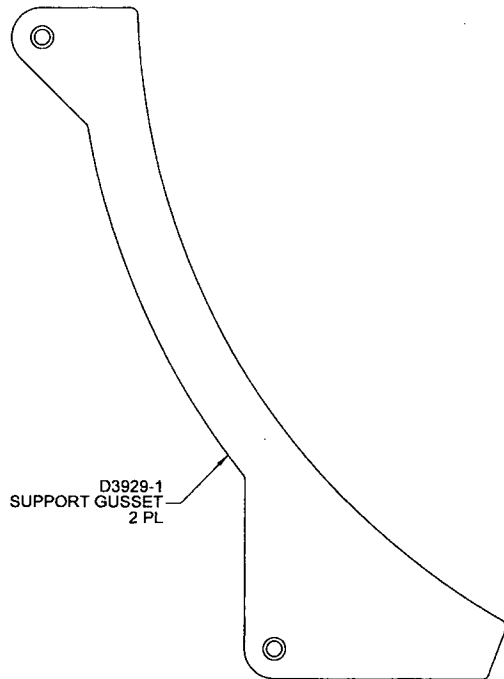
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D

C

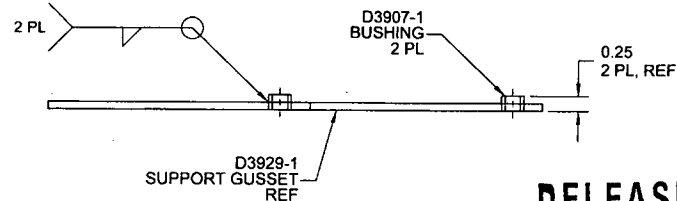
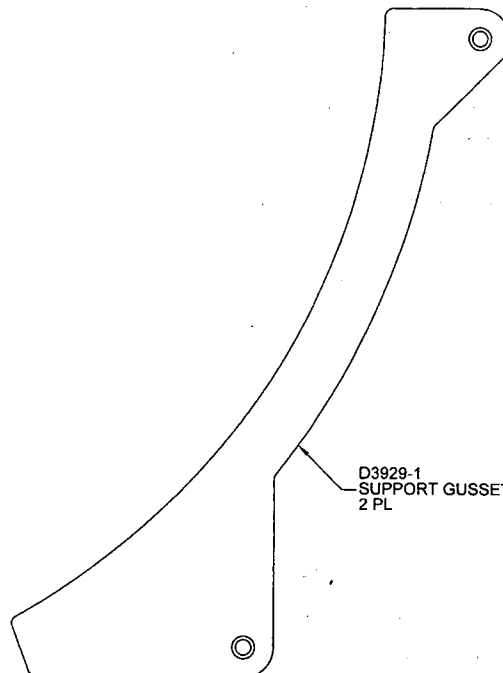
B

A



D3929-041 GUSSET ASSEMBLY

cto 59024



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22 MD

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	<i>[Signature]</i>	DRAWING NO. D3929	REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE GUSSET ASSEMBLY	SHEET 2 OF 3
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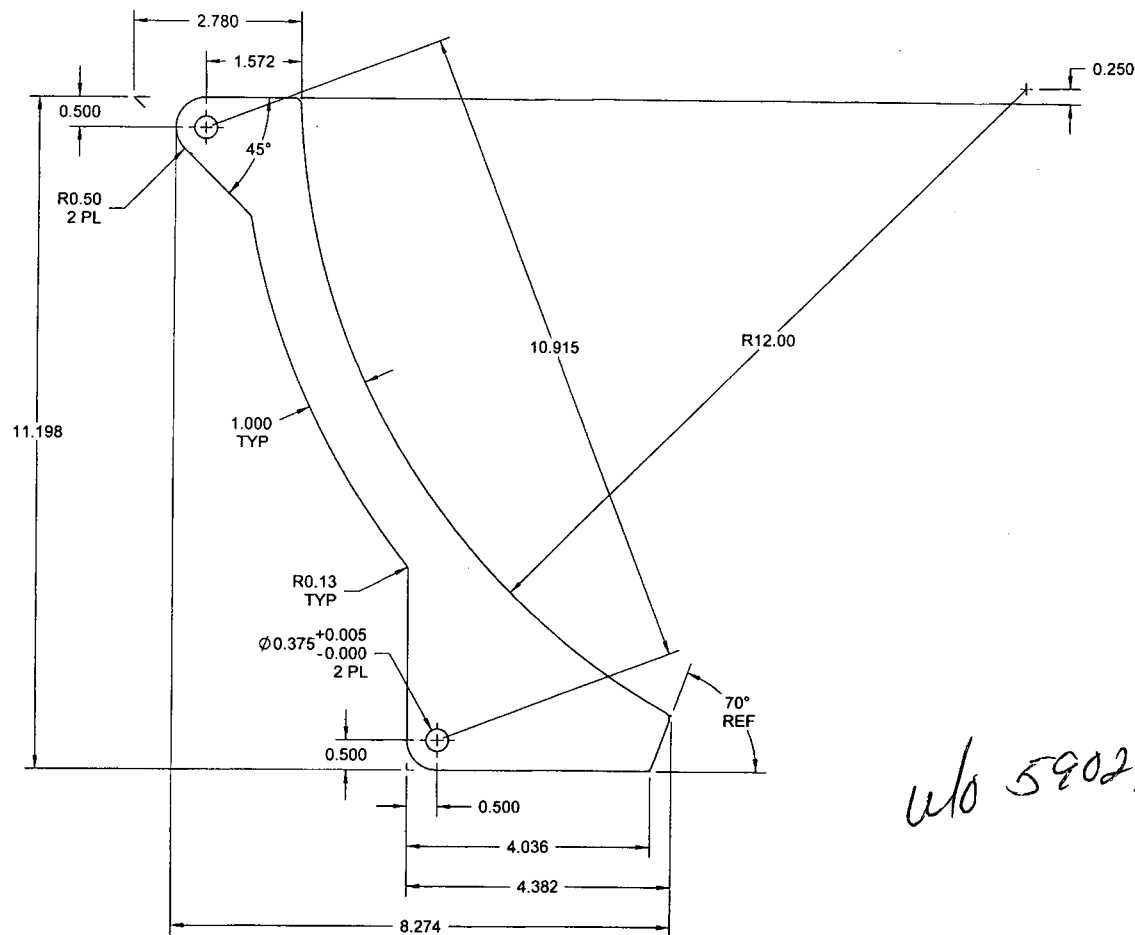
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




NOTE: Date & initial all entries



D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

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MFG. APPR.		D3929	SHEET 3 OF 3
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RELEASED
07/07/2010

W/ 59029

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